

Date: Thursday, 22/01/2009 2:05:15 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BASE PLATE PANEL
Job Number :	45081		
Estimate Number :	11213		
P.O. Number :		Part Number :	D33331
This Issue :	22/01/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3333 REV B
First Issue :	/ /	Project Number :	N/A
Previous Run :	43348	Drawing Revision :	B
	Type :	Material :	
	SMALL / MED FAB	Due Date :	05/02/2009
Written By :		Qty:	10
Checked & Approved By :	JUL 09.01.22	Um:	Each
Comment :	Est. C 05.04.15 Made in-house KJ/JLM Est Rev:D Now on Waterjet 07-03-29 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4140N-B0.625x04.000	AISI 4140 Steel Bar 625 x 4.000
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Comment: Qty.: 0.7984 f(s)/Unit Total : 7.9842 f(s)
 AISI 4140 Steel Bar
 Material: AISI 4140 Steel Minimum yield tensile strength: 100ksi
 (M4140N-B0.625x04.000)
 Identify for D3333-1
 Batch: 110337 B9-3-22

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3333
 Dwg Rev: B
 Prog Rev: B

B9-3-22

(10)

2-Deburr if necessary B9-3-22

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



B9-3-22

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

S09/03/23 (4/10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 22/01/2009 2:05:15 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASE PLATE PANEL

Job Number: 45081

Part Number: D33331

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Open hole to .201" then tap 1/4"-20nc as per Dwg D3333

ml 01/03/24

(10)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SA 09/03/24

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Deburr

SA 09/03/25

10

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

Mask threaded holes.

START TIME:

11:15am

OVEN TEMPERATURE:

320°F

FINISH TIME:

11:45am

SA 09-04-16

(210)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 04-04-16

(10)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Can

9/4/17

SL

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/22

Job Completion



0209/04/17

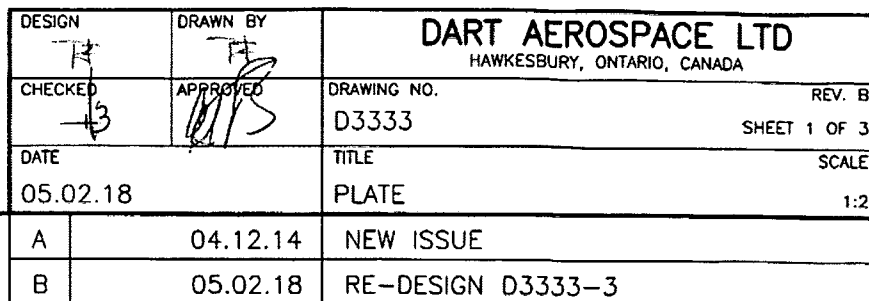
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

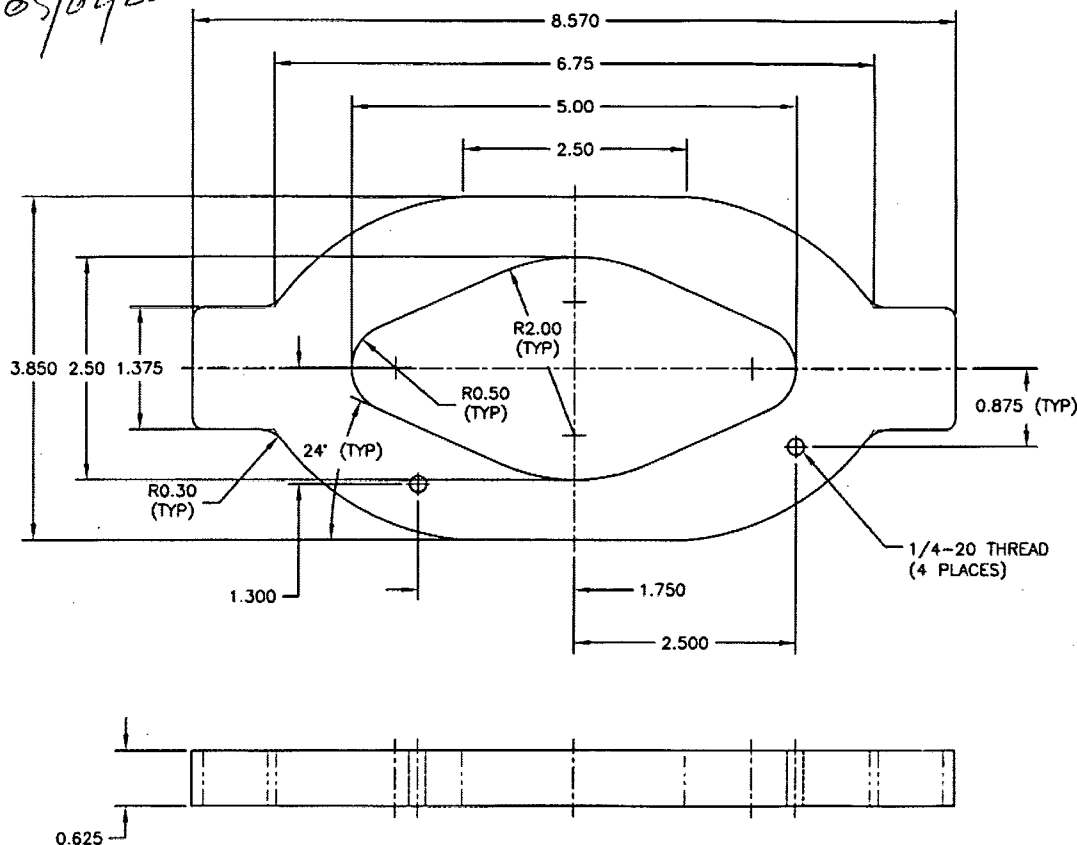
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED

05/02/22



D3333-1 BASE PLATE PANEL

NOTES:

- 1) MATERIAL: AISI 4140 STEEL 0.625 THICK STEEL (REF. DART SPEC. M4140-B)
MIN. YIELD TENSILE STRENGTH = 100 ksi
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- RETURN TO
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WITHOUT NOTICE
WORK ORDER
115081

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140-B)
RETURN TO
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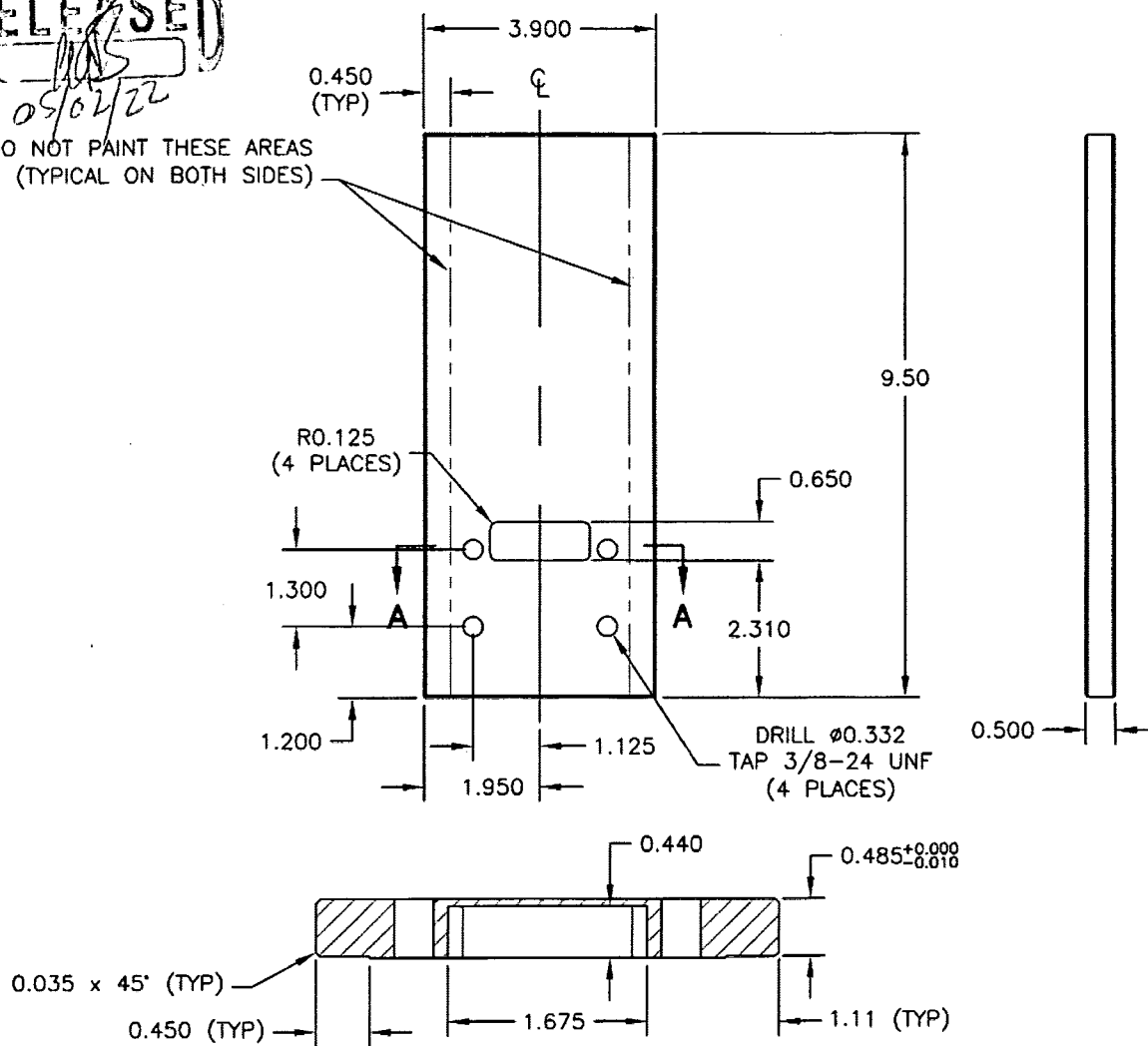
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DESIGN 13	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3333	REV. B SHEET 2 OF 3
DATE 05.02.18		TITLE PLATE	SCALE 1:4

RELEASED
05/02/22DO NOT PAINT THESE AREAS
(TYPICAL ON BOTH SIDES)**SECTION A-A****D3333-3 SLIDING PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 0.50 THICK MILD STEEL (REF. DART SPEC. M1010-B)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

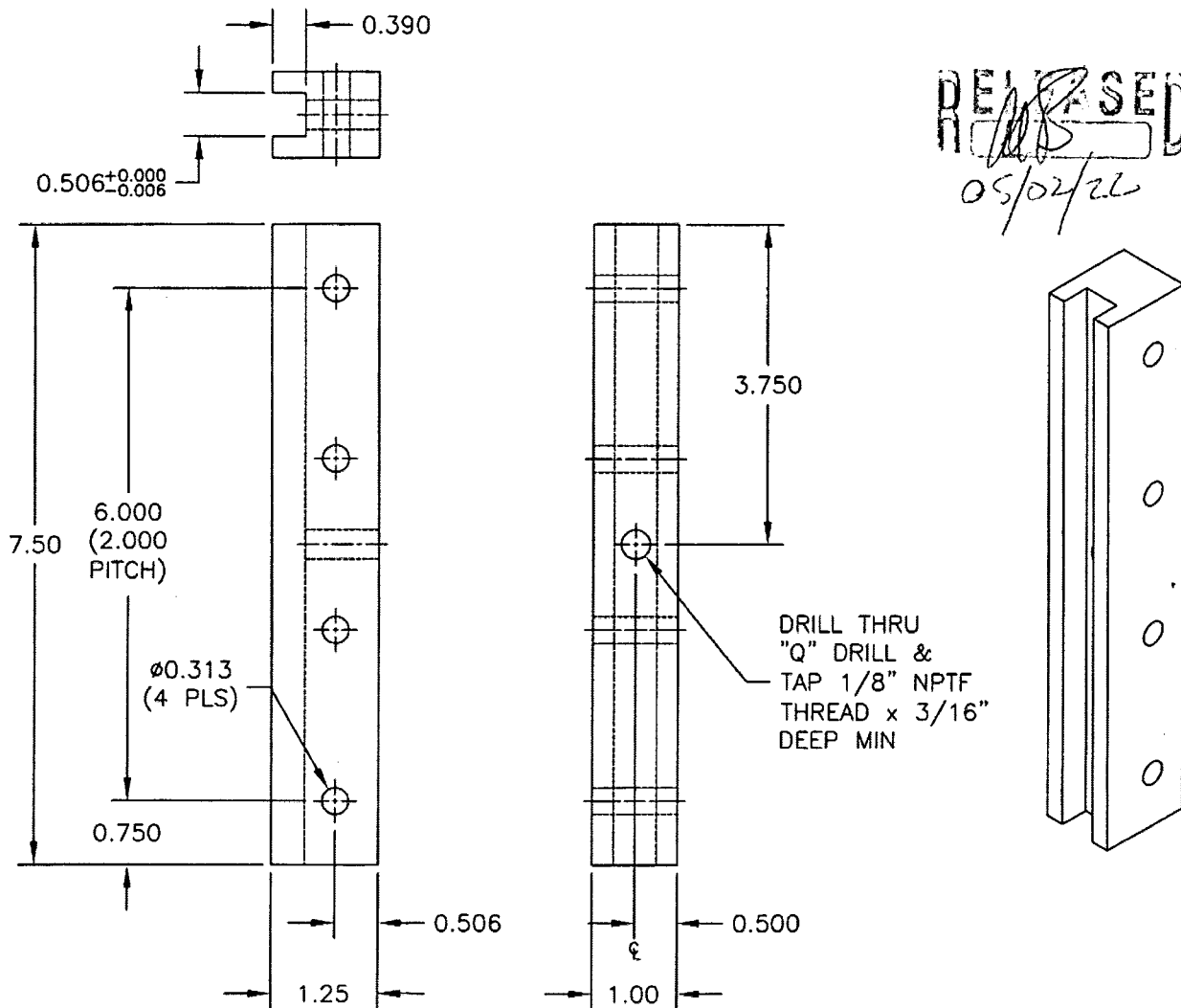
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3333	REV. B SHEET 3 OF 3
DATE 05.02.18		TITLE PLATE	SCALE 1:2

**D3333-5 RAIL****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.00 THICK STEEL (REF. DART SPEC. M1010-B)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3 WITHOUT NOTICE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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